

Date: Friday, 9/21/2007 1:17:52 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE KIT
 Job Number : 34809
 Estimate Number : 10532
 P.O. Number : *NA* Part Number : K10003
 This Issue : 9/21/2007 S.O. No. : *NA* Drawing Number : IIN D205-634 REV D
 Prsht Rev. : NC Project Number : N/A
 First Issue : 9/21/2007 Type : SMALL /MED FAB Drawing Revision : D
 Previous Run : 34355 Material : *NA* Due Date : 10/20/2007 Qty: *13* Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est : I 03.01.16 Reformat: Incorporated D205-641-011
 KJ/RF
 Est : J 06-07-25 As per DSI 9344
 JLM
 Est : K 06.11.17 Per K10003 Rev C
 KJ
 Est Rev: L 07.01.12 Document Record for copying bluefile rmv
 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Create White labels only per PPP K10003 CHG 005

Copy 02.11.01

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D2570 Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total : 288.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
24	D2570	Bushing	<i>34811</i>

34811

4.0 D2571 Saddle, Fwd, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle	<i>32165</i>

31719
31806
6/10/12
54

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:17:52 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 34809

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2572

Saddle, Fwd, In



(P10)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty	Part Number	Description	Batch
1	D2572	Saddle	34328

5 8 SP 34749

6.0

D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty	Part Number	Description	Batch
1	D2573	Saddle	34750

SP 34369

7.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle, Aft, In

Pick:

Qty	Part Number	Description	Batch
1	D2574	Saddle	34815

* 34370 4 8 34751

8.0

D27361

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-1	Bracket	33469

SP

9.0

D27363

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-3	Bracket	33566

4/10/3180

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: K10003 PAR #: N/A Fault Category: Part/Labeling NCR: (Yes) No DQA: (X) Date: 02/11/05
 QA: N/C Closed: (X) Date: 07.11.06

NCR: <u>34809</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07-10-01</u>	<u>5.0</u>	<u>3x D2572 were packaged & identified as D2579 B34749. Saddles in form are D2572.</u> <u>R.C. Human error (New employee) & assisted by trainer.</u>	<u>(Signature)</u> <u>05/10/02</u>	<u>re-identify with the correct part #</u>	<u>(Signature)</u> <u>07-10-01</u>	<u>(Signature)</u> <u>07-11-07</u>	<u>(Signature)</u> <u>05/10/02</u>	<u>(Signature)</u> <u>07-10-01</u>

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Drawing Name: SADDLE KIT

Job Number: 34809

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Set Screw

Pick:

Qty	Part Number	Description	Batch
4	D2747	Socket Head Set Screw	33470

SP

11.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2876	Spacer	029789

SP

PTO

12.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2877	Spacer	32109

SP

13.0

D2968041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Tow Ring

Pick:

Qty	Part Number	Description	Batch
1	D2968-041	Tow Ring	30274

SP

14.0

D35331

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Set Screw

Batch:

173470 1328093

SP

15.0

AN46A

Bolt



M10S057

M104322



Comment: Qty.: 16.0000 Each(s)/Unit Total : 192.0000 Each(s)

Bolt


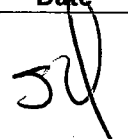
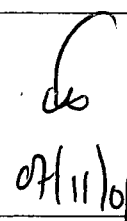
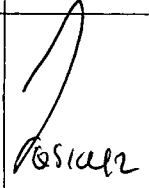
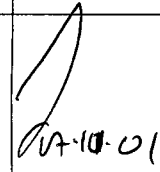
Pick:

7/10/31 SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: K10003 PAR #: HM Fault Category: Prod / Assembly NCR: Yes No DQA: LD Date: 07/11/05
 QA: N/C Closed: _____ Date: _____

NCR: <u>31805</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-10-01	110	D2876 B29789, were mis-ident. tied in 4 kits, as D2877 B29789. R.C. Human error		re-identify parts correctly		 07/11/05		 07-10-01

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 34809

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty	Part Number	Description	Batch
16	AN4-6A	Bolt	

16.0

AN446A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
4	AN4-46A	Bolt	M104925

SP

17.0

AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN4-51A	Bolt	M105281

SP

12

M105810

18.0

AN612A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN6-12A	Bolt	M10558

SP

19.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 384.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
32	AN960JD416	Washer	M104746

360

SP

36

M105426

20.0

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
8	AN960JD616	Washer	M104745

7/10/16 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: SADDLE KIT

Job Number: 34809

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

1

AN970-4

Washer

M104885 \ SQ

22.0

MS21042L4

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 348.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

29

MS21042L4

Nut (or MS21042-4)

M19099

M104683 \ 7/10/12

50
(12)

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

8/10/12

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

NEW

6/7/11/0-2

(13)

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

8/11/05
(13)

Job Completion



U OF 11-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED #	DRAWING NO. K10003	REV. C SHEET 1 OF 1
DATE 06.11.07		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	
C	06.11.07	ADD D3533-1	

RELEASED

06.11.13 #

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/210/212/412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
D3533-1	2	2	2
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

* REQUIRED WITH D2707-041 ONLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
1 SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34809

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